

Date: Thursday, 02/04/2009 2:28:21 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : INTERIOR TRIM KIT (CEILING TRIM KIT)
 Job Number : 46876
 Estimate Number : 13261
 P.O. Number :
 This Issue : 02/04/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D350766013
 First Issue : / / Type : THERMOFORMING Drawing Number : IIN 350-766 REV A
 Previous Run : 46875 Drawing Revision : A
 Material :
 Due Date : 17/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.04.03
 Comment : EST REV A NEW ISSUE 08/04/08 DL verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-766-013

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D36561 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: B47021

4.0 D36563 PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PANEL

batch: 47022

5.0 MS21059L3 Nut Plate



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut Plate

batch: M107394 X3 M109962 X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INTERIOR TRIM KIT (CEILING TRIM KIT)

Job Number: 46876

Part Number: D350766013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	CCR264SS33	Cherry Rivet
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Comment: Qty.: 30.0000 Each(s)/Unit Total : 30.0000 Each(s)

Cherry Rivet

batch:

M110625 x 1/4"

M111548 x 1/6"

8809/04/17 (4)

7.0	AN5261032R9	Screw
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Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Screw

batch:

M110584

8809/04/17 (4)

8.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

802/04/09 (4)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-766-013

Location:

PPP Rev:

B

89/04/29 (1)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/04/30 (4)

Job Completion



MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

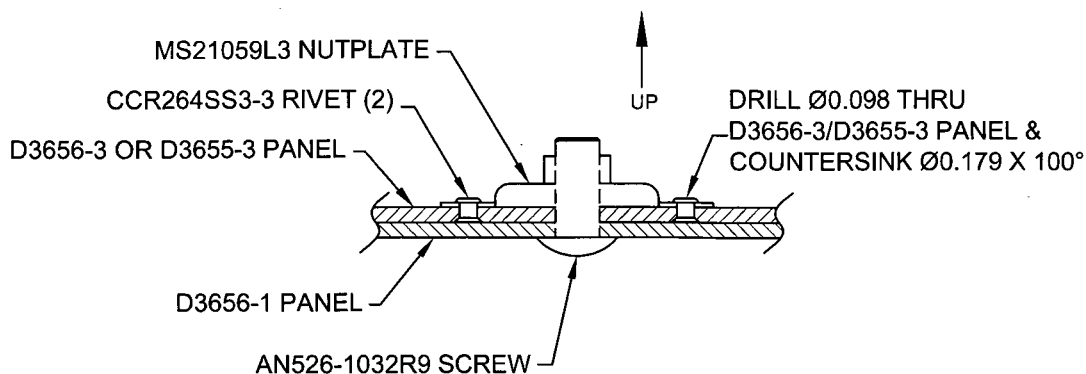


Figure 6 – Nutplate Installation

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb 6.0 kg	0 in 0 m	0 in-lb 0 m-kg	113 in 2.87 m	1492 in-lb 17.2 m-kg
D350-766-013 Interior Trim Kit (Ceiling Trim Kit)	11.0 lb 5.0 kg	0 in 0 m	0 in-lb 0 m-kg	91 in 2.31 m	1001 in-lb 11.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X	D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
1		D3655-1	PANEL
1		D3655-3	PANEL
	1	D3656-1	PANEL
	1	D3656-3	PANEL
4	15	MS21059L3	NUTPLATE
	30	CCR264SS3-3	RIVET
8		CCR274SS3-4	RIVET
	15	AN526-1032R9	SCREW
2		AN526-1032R12	SCREW
2		AN526-1032R20	SCREW

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ENGINEERING

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06874